

Work Order ID 53974



Page 1

November 24, 2009 2:29:56 PM

Item ID: D3574-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cabin Floor Protector

Start Date: 25/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*

Date: *07-11-24*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☒ Dwg Rev: *S* ☐ Prog Rev: *S* ☐ 2-
Deburr if necessary

12-11-30

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

12-11-30

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 809/11/30

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53974

November 24, 2009 2:29:56 PM



Page 2

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Start Date: 25/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr if necessary.

9/20/09/12/01 (4)

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

2/5 02/12/01

(4) 0

150



Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

9/12/01 SQ (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November 24, 2009 2:29:56 PM



Accept

**Setup Start**

Stop



Start Date: 25/11/2009 **Start Qty:** 4.00

**Cust Item ID:**

Required Date: 02/12/2009 **Req'd Qty:** 4.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation	Description
1	...
2	...
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96	...
97	...
98	...
99	...
100	...

Set Up/ Run Hours

**Draw
Number**

Draw
Rev.

**Plan
Code**

**Accept
Qty**

Reject
Qty**Reject
Number**

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/01

PL 04-121

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 24, 2009 2:30:02 PM

Page 1

Work Order ID: 53974



Parent Item: D3574-1RevB



Parent Item Name: Cabin Floor Protector

Start Date: 25/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MLEXS.125-F60029-04		Purchased	No				sf	2,509.138	134.4672			
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B9-11-30

GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	2509.138698	
103106	7.8	
105330	54	
109455	46.695	
111710	329.893632	
112585	2070.75007	

112585

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	53974
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	X			
7.37	+/-0.030	7.37	X			
10.75	+/-0.030	10.75	X			
11.00	+/-0.030	11.00	X			
15.25	+/-0.030	15.25	X			
25.87	+/-0.030	25.87	X			
39.75	+/-0.030	39.75	X			
44.75	+/-0.030	44.75	X			
49.11	+/-0.030	49.11	X			
51.11	+/-0.030	51.11	X			
53.51	+/-0.030	53.51	X			
63.50	+/-0.030	63.50	X			
65.25	+/-0.030	65.25	X			
10.75	+/-0.030	10.75	X			
11.06	+/-0.030	11.06	X			
14.75	+/-0.030	14.75	X			
25.50	+/-0.030	25.50	X			
25.75	+/-0.030	25.75	X			
26.00	+/-0.030	26.00	X			
32.87	+/-0.030	32.87	X			
38.81	+/-0.030	38.81	X			
44.75	+/-0.030	44.75	X			
45.00	+/-0.030	45.00	X			
48.25	+/-0.030	48.25	X			
58.38	+/-0.030	58.38	X			
61.25	+/-0.030	61.25	X			
64.13	+/-0.030	64.13	X			
64.63	+/-0.030	64.63	X			
66.50	+/-0.030	66.50	X			
7.50	+/-0.030	7.50	X			
9.50	+/-0.030	9.50	X			
10.38	+/-0.030	10.38	X			
10.88	+/-0.030	10.88	X			
14.50	+/-0.030	14.50	X			

DART AEROSPACE LTD		Work Order:	
Description: Cabin Floor Protector		Part Number:	D3574-1
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.56	+/-0.030	16.56	✓			
18.75	+/-0.030	18.75	✓			
24.13	+/-0.030	24.13	✓			
26.50	+/-0.030	26.50	✓			
30.50	+/-0.030	30.50	✓			
33.88	+/-0.030	33.88	✓			
39.50	+/-0.030	39.50	✓			
40.25	+/-0.030	40.25	✓			
43.50	+/-0.030	43.50	✓			
43.83	+/-0.030	43.83	✓			
46.60	+/-0.030	46.60	✓			
7.63	+/-0.030	7.63	✓			
11.00	+/-0.030	11.00	✓			
11.50	+/-0.030	11.50	✓			
16.75	+/-0.030	16.75	✓			
19.00	+/-0.030	19.00	✓			
22.50	+/-0.030	22.50	✓			
30.75	+/-0.030	30.75	✓			
32.63	+/-0.030	32.63	✓			
32.75	+/-0.030	32.75	✓			
35.13	+/-0.030	35.13	✓			
36.50	+/-0.030	36.50	✓			
40.00	+/-0.030	40.00	✓			
41.88	+/-0.030	41.88	✓			
43.63	+/-0.030	43.63	✓			
0.125	+/-0.010	0.130	✓			

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	9-11-30	Date:	09/11/30	Date:	N/A

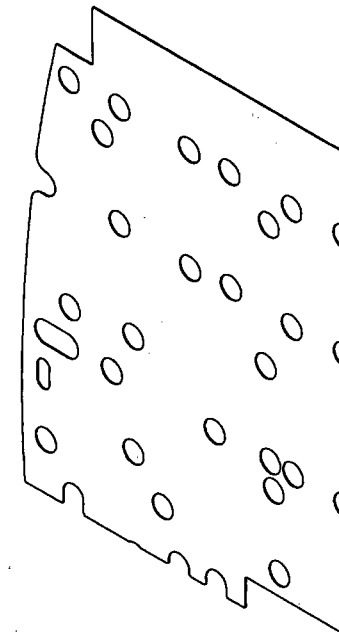
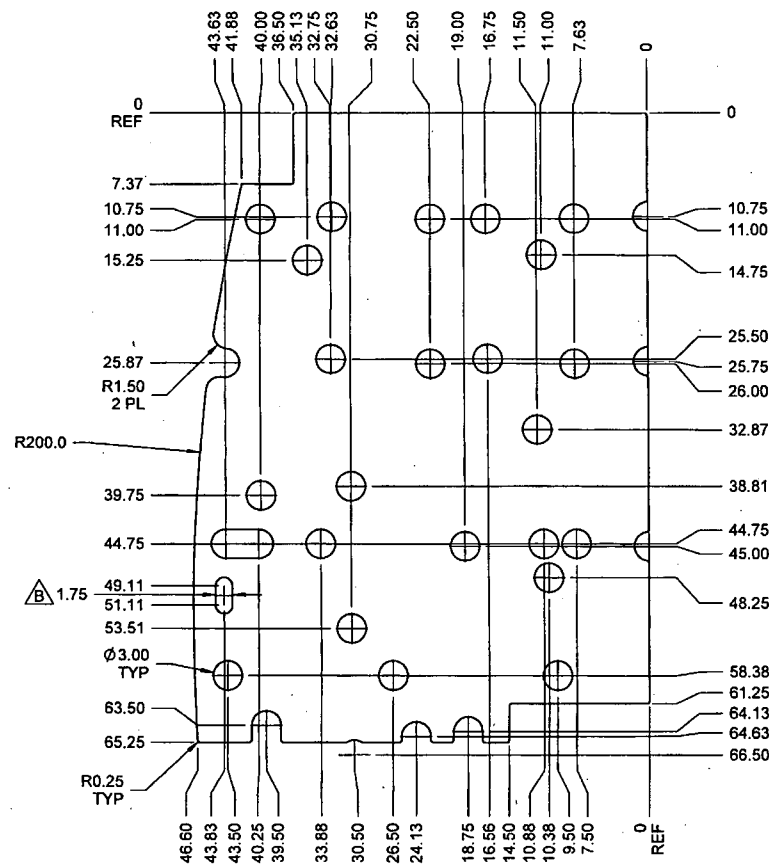
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 53974
8109-11-24



RELEASED
01/24/07

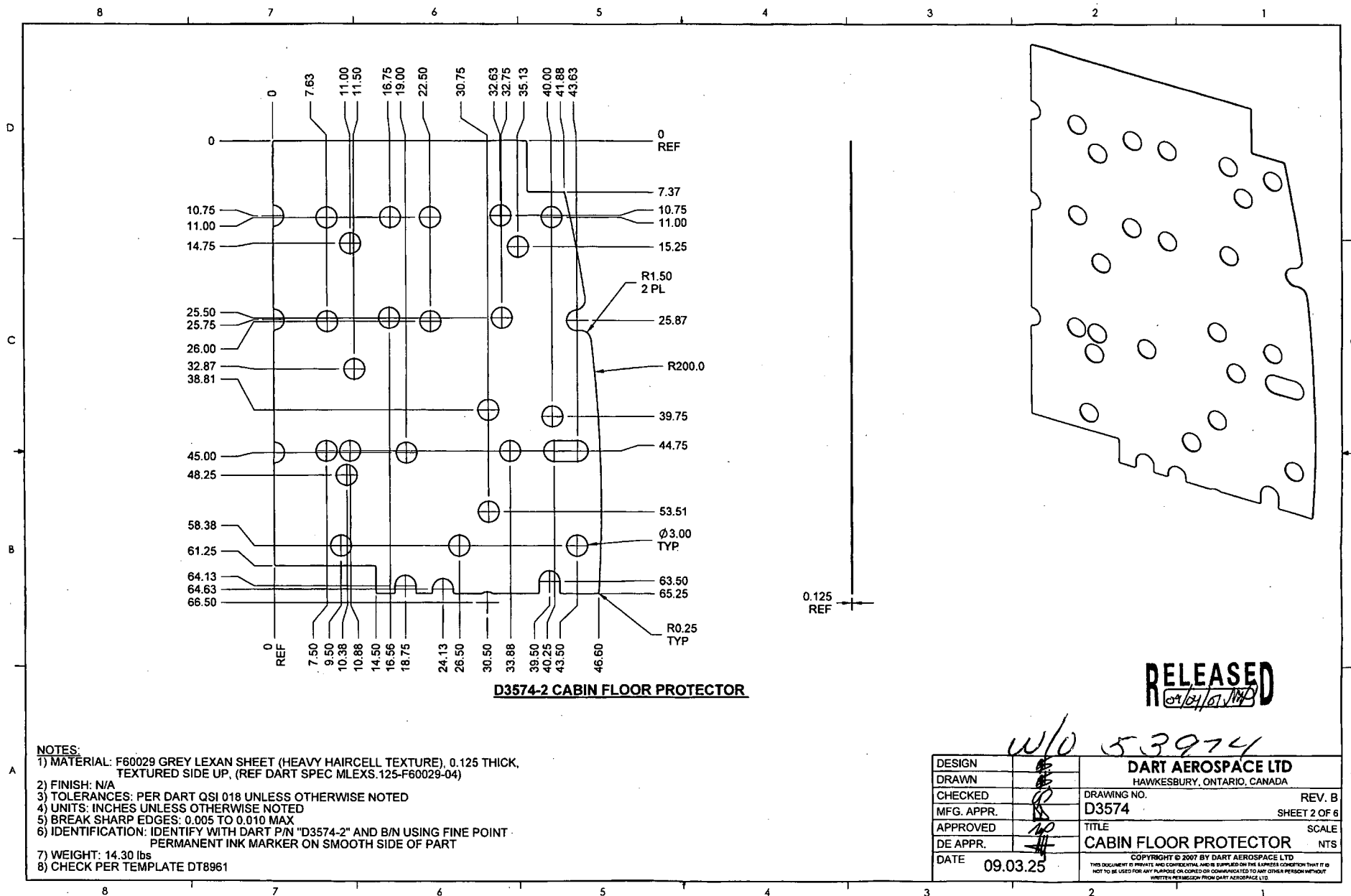
D3574-1 CABIN FLOOR PROTECTOR

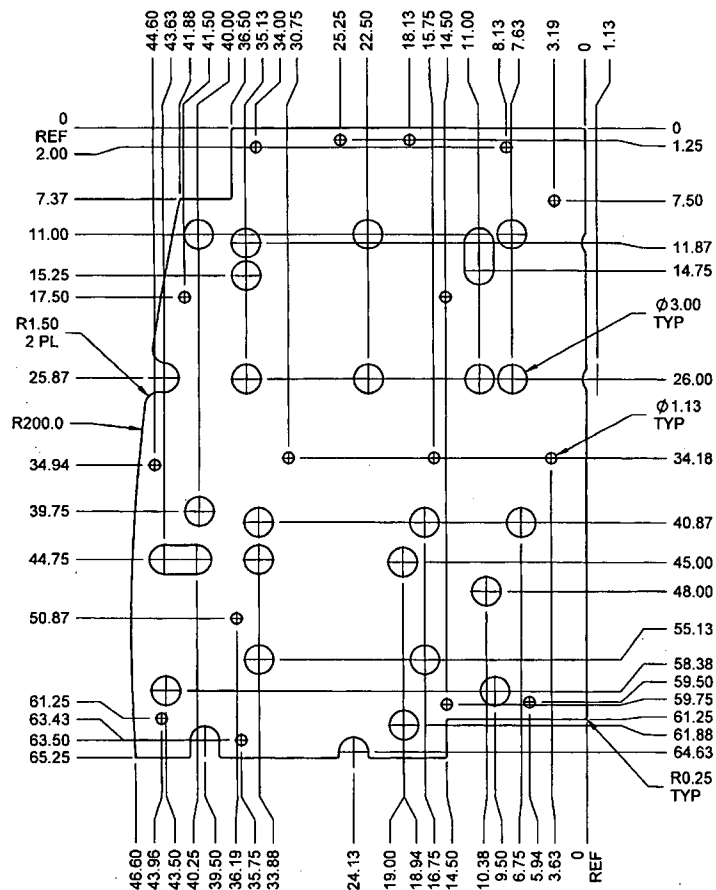
NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961

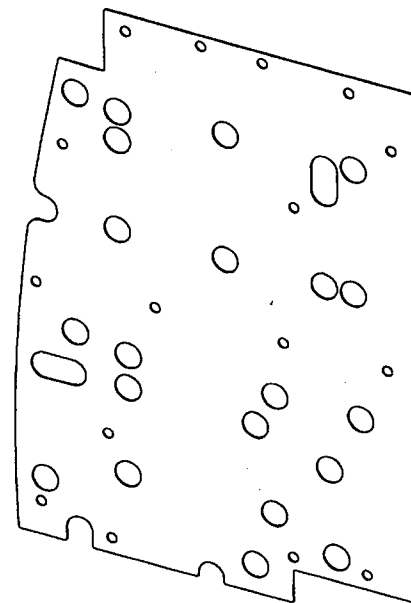
B	ADD CUT-OUT TO -1/5 FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5, -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	07.06.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3574	REV. B SHEET 1 OF 6
TITLE CABIN FLOOR PROTECTOR	SCALE NTS
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D3574-3 CABIN FLOOR PROTECTOR



RELEASED
07/14/07

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-3" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.33 lbs
- 8) CHECK PER TEMPLATE DT8962

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3574	REV. B
MFG. APPR.		SHEET 3 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		CABIN FLOOR PROTECTOR	NTS
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